

Work Order ID 81569

Duplex
81569

Page 1

April-13-12 7:08:43 AM

Item ID: D3265-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Base Assembly

Start Date: 3/15/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/13/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3265

Rev C

100

Weld per dwg A/R S.S. rod Batch: 118366 0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Drill hole in D3265-3 as per Dwg D3265 ****ONLY DRILL WHEN
ASSEMBLING WITH D3267-041/-043 LID, AS PER SHEET 2 NOTE 10 ***
2-Remove all markings from material
3-Weld as per Dwg D3265 using DT9444 Deburr as required
4-cut mesh

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

1X

Ø

Plc
12.04.14

SH 12.04.16

12.04.16

Work Order ID 81569

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Page 2

Item ID: D3265-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Base Assembly

Start Date: 3/15/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/13/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

130

Powdercoat

Powder Coating

Memo

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

****if necessary****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

1:15
400 OF

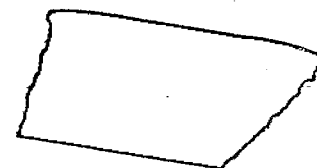
1:45

2:00

400 OF

2:30

M121134



M-1
12/04/16

Work Order ID 81569

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Page 3

April-13-12 7:08:43 AM

Item ID: D3265-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Base Assembly

Start Date: 3/15/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/13/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

1 0 12-4-16

150

Small Fab

0.00

150

Small Fab

Memo

0.00

Small Fab

Seal support gusset seam with White Sikaflex-291

Batch: 121221

Expiry date: 13-01

1 0 12-4-16

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

8/26/12

Work Order ID 81569

81569

Page 4

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Item ID: D3265-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Base Assembly

Start Date: 3/15/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/13/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location:

D350-007-017A.

81564

170

Packaging

Memo

0.00

Packaging

1 4

BL 12-4-17.

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/4/17

MF

12-04-17

Picklist Print

April-13-12 7:08:42 AM

Page 1

Work Order ID: 81569

Parent Item: D3265-041

Parent Item Name: Basket Base Assembly

Start Date: 3/15/12

Required Date: 4/13/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:C Re-Format 05-11-03 JLM

IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC IPP RevE: as per DEO DD

10.09.12 verified by:EC IPP RevF: revise seq 110 DD 10.01.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2232-3

Basket Hinge

Manufactured

No

100

Each

19.0000

2

3AD 12-04-12

Location

Loc Qty

Loc Code

WA

13

82304

13

WA005

6

75581

2

78903

4

(2)

D2235-1

Basket Rib

Manufactured

No

100

Each

20.0000

1

SAD 12-09-13

Location

Loc Qty

Loc Code

WA

15

78636

5

81910

10

WA005

5

66895

4

79153

1

B81910

(1)

D2327-3

Spacer Bushing

Manufactured

No

100

Each

13.0000

2

SAD 12-09-13

Location

Loc Qty

Loc Code

WA005

13

75564

1

77229

1

81144

11

2

Picklist Print

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Page 2

Work Order ID: 81569

Parent Item: D3265-041

Parent Item Name: Basket Base Assembly

Start Date: 3/15/12

Required Date: 4/13/12

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No
Mounting Bracket

100 Each 32.0000 2

² S/D 12-04-13

Location	Loc Qty	Loc Code
WA	26	
82506	26	
WA005	6	
69739	1	
70766	2	
77045	1	
81253	2	

2
2
2
2
2
2
2

D3442-5 Manufactured No
Shim

100 Each 22.0000 4

⁴ S/D 12-04-13

Location	Loc Qty	Loc Code
WA005	22	
33282	22	

4

D3826-041 Manufactured No
Rib / Gusset Assembly

100 Each 6.0000 2

² S/D 17-04-13

Location	Loc Qty	Loc Code
WA	6	
81398	6	

2

D3833-1 Manufactured No
Mesh (Base End Face)

100 Each 7.0000 2 2

P/L 12-04-14

Location	Loc Qty	Loc Code
WA	5	
77521	5	
WA035	2	
79335	2	

2

April-13-12 7:08:43 AM

Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 81569

Parent Item: D3265-041

Parent Item Name: Basket Base Assembly

Start Date: 3/15/12

Required Date: 4/13/12

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100 sf

947.2254

26

27.368421

Expanded Metal Flat SS

SM 12-04-13

Location

Loc Qty

Loc Code

MAT

320

121347

320

WA

0.0001156

119180

0.0001156

WA035

627.2252641

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

28.1132686

120153

2.97557478

120917

170.88713

121082

80.14

M121347

27.3685

M304TS0.750W.065

Purchased

No

100 f

1.072.6352

18.3

19.263158

304 SQ Tube .75x.75x.065W

SM 12-04-13

Location

Loc Qty

Loc Code

MAT017

553.7325342

120267

53.7325342

120633

500

MAT018

512.24519

121170

471.24519

7636

41

WA007

0.5907428

116763

0.5907428

WA035

6.0667

118181

6.0667

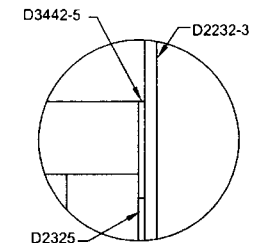
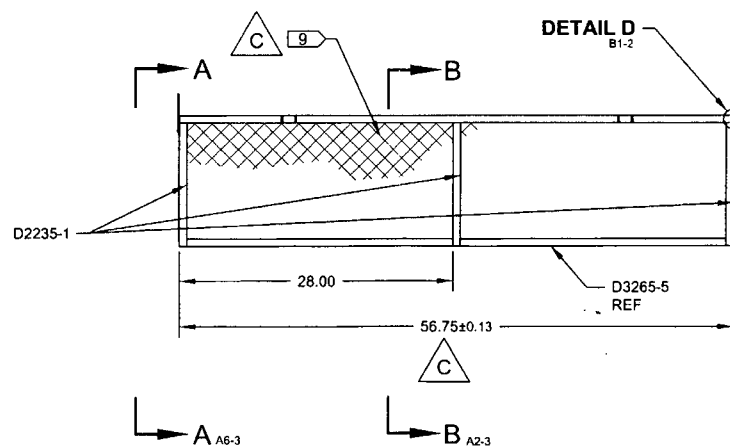
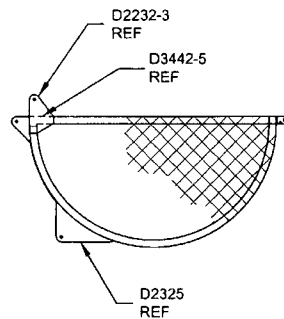
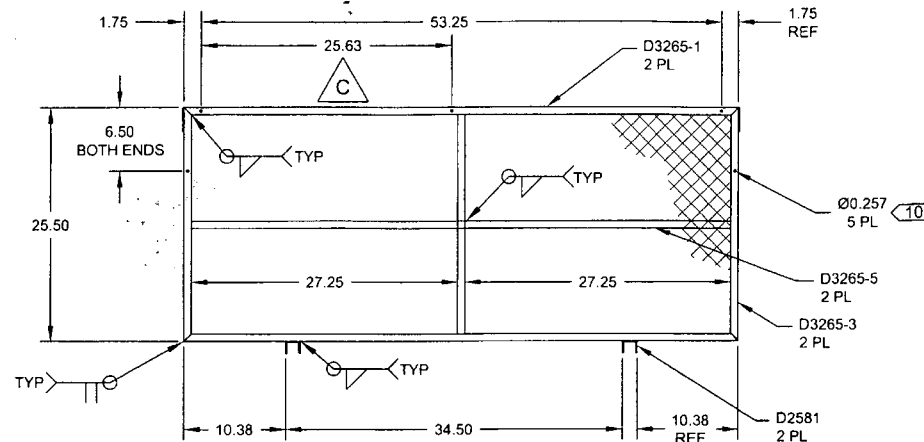
19-2632

April-13-12 7:08:43 AM

Shop Packet Print

Page 3

8 7 6 5 4 3 2 1



DETAIL D C4-2
(BOTH ENDS)
SCALE 10X

DEO ATTACHED
RELEASED



BASE ASSEMBLY NOTES:

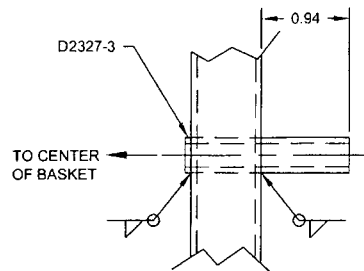
- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) SKIN INSIDE SURFACE OF BASKET WITH EXPANDED STEEL MESH.
TACK WELD EACH END OF STRAND TO FRAME.
- 10) DRILL WHEN ASSEMBLING WITH D3267-041/-043 LID ONLY.

D3265-041 BASKET BASE ASSEMBLY

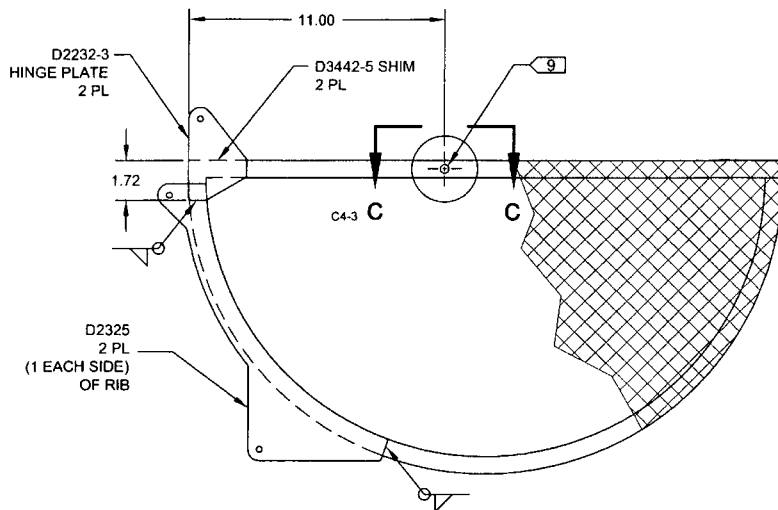
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	REV. C
MFG. APPR.	RE	D3265	SHEET 2 OF 4
APPROVED	RE	TITLE	SCALE
DE APPR.	RE	BASKET BASE ASSEMBLY (350)	NTS
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8 7 6 5 4 3 2 1

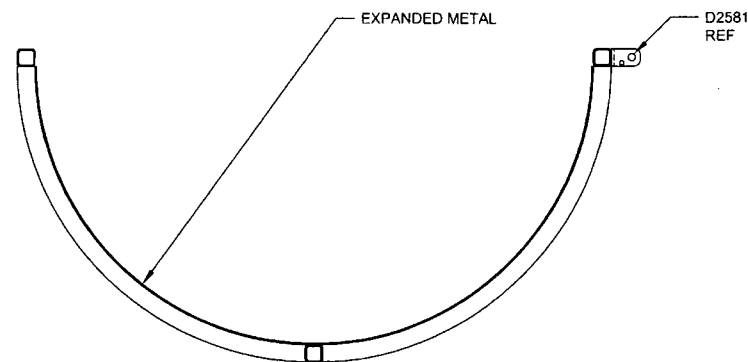
8 7 6 5 4 3 2 1



VIEW C-C B7-3
2 PL
SCALE 4X
ROTATED 90° CCW



SECTION A-A A5-2
2 PL
(BOTH END RIBS)



SECTION B-B A4-2
2 PL
(BOTH CENTER RIBS)

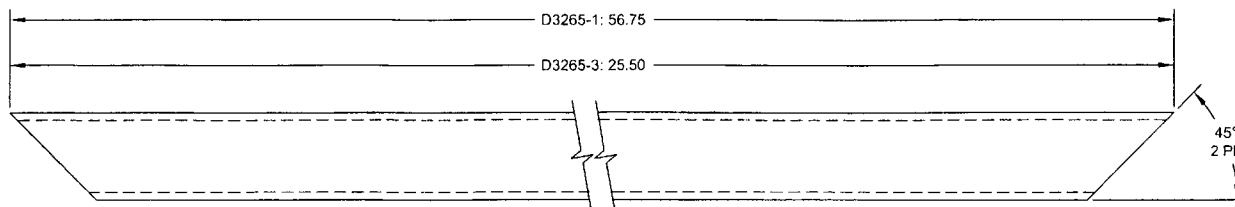
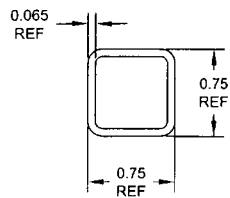
DEO ATTACHED
RELEASED
08-09-04 N/A

NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DRILL 3/8 HOLE AND INSTALL D2327-3 USING CLOSEST SPACE IN EXPANDED METAL FOR HOLE LOCATION BOTH ENDS

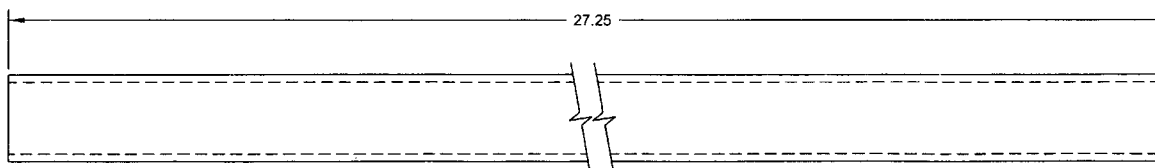
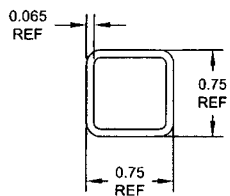
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3265	SHEET 3 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET BASE ASSEMBLY (350)	NTS
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8 7 6 5 4 3 2 1



D3265-1 RIB

D3265-3 RIB



D3265-5 RIB

**DEO ATTACHED
RELEASED**
08-09-14

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	REV. C
MFG. APPR.	RE	D3265	SHEET 4 OF 4
APPROVED	RE	TITLE	SCALE
DE APPR.	RE	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3265-C-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>PH</i>	CHECKED <i>PH</i>	MFG. APPR. <i>PH</i>	APPROVED <i>PH</i>		DE APPR. <i>PH</i>		
DATE 09.04.16	DATE 09.04.16	DATE 09.04.16	DATE 09.04.16		DATE 09.04.16		

SHEET 1, MODIFY PARTS LIST AS FOLLOWS:

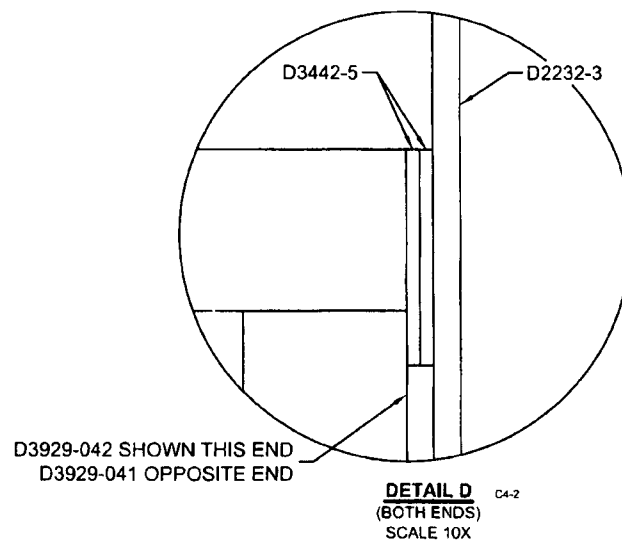
IS:

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
3	D2235-1	RIB
2	D3929-041	GUSSET ASSEMBLY
2	D3929-042	GUSSET ASSEMBLY
4	D3442-5	SHIM

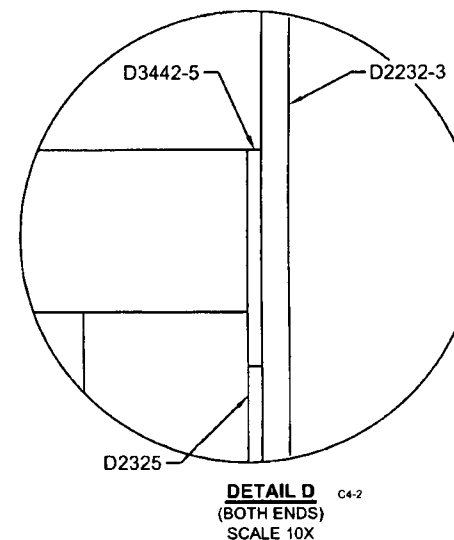
WAS:

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D3442-5	SHIM

SHEET 2, MODIFY DETAIL D AS SHOWN:



RELEASED
01/04/22

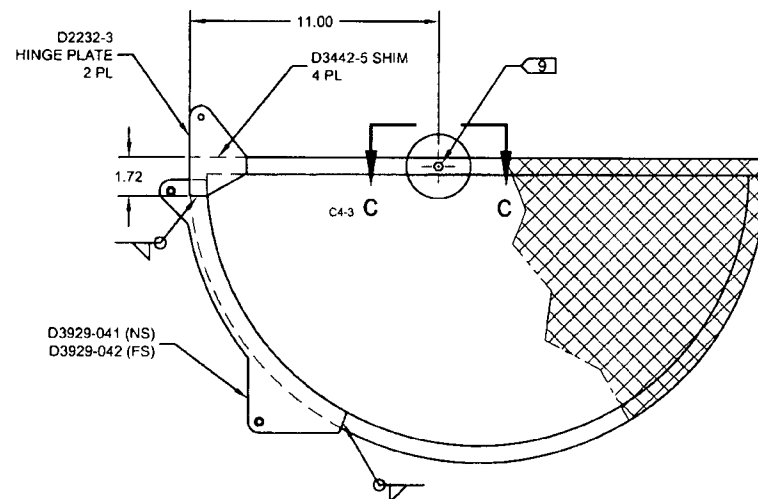


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DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3265-C-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN <i>LB</i>	CHECKED <i>PH</i>	MFG. APPR. <i>AD</i>	APPROVED <i>HH</i>	DE APPR. <i>HH</i>		
DATE 09.04.16	DATE 09.04.16	DATE 09/04/17	DATE 09.04.17	DATE 09.04.17		

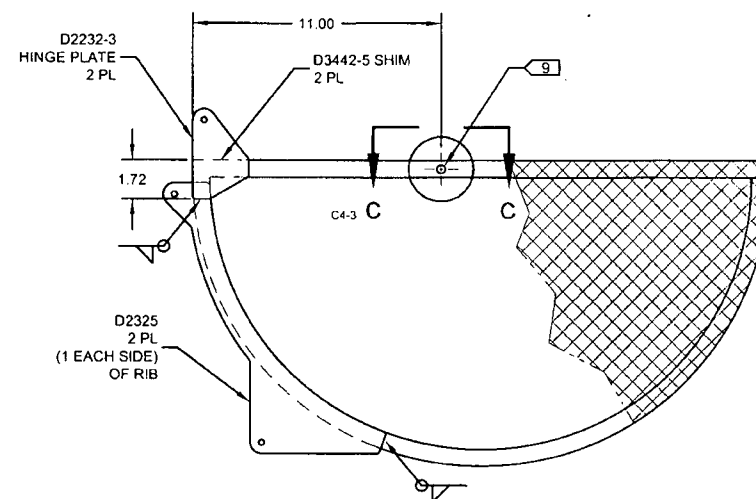
SHEET 3, MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A A5-2
2 PL
(BOTH END RIBS)

WAS:



SECTION A-A A5-2
2 PL
(BOTH END RIBS)

RELEASED
09/04/17